Shir Lug 15

Work Order I Tuesday, August 12, 2					*120	1348*							Page 1
Revision ID: Item Name: Angl			ral		Accept	*N900	1 040	100) * :	Setup	Start Stop		S1* S2*
Start Date: 6/04		Start Qty: 6.00		*6*		Cust Item							
Required Date: 6/04		Req'd Qty: 6.00	•	*6*		Customer	**						
Approvals: Pro	ocess Rla	ny	Date: []	-8-12	Tooling:]	Date:	· -	I	Run	Start	*N	R1*
QC	:	U	Date:		SPC (Y/N):]	Date:				Stop	*N	R2*
Sequence ID/ Work Center ID	,	Operation • Description	· · ·	15,	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr -	Rev	ision Nbr					1.6	***************************************					14
D3602	Rev	В				•			;				
100		FLOW WATER JET			0.00		-		(6)	,	š.	a/o	14/08/1
Waterjet FLOW CNC Waterjet		Memo ***USE S	TAINLESS WIT	H PLASTIC	0.00 WRAP***						₹,		
		1-Cut as p Dwg Rev	er Dwg D3602 : 15										٠.
	,	Prog Rev:	<u> </u>					•					•
	•	2-Deburr	if necessary			·.			*				
*110		QC2- Inspect parts off	machine FAI/FA	AIB .	0.00						A	/pc	14/28/1=
QC Quality Control		Memo	•		0.00				<u> </u>			<i>, ,,</i>	11/00/10

DQA:	•		Date:												*DART
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		Mark O	rdar ur	odate only	_	AEROSPACE .
QA Closed.			Date.				_				VOIRO	ruer up	date only		
Work Orde	or.					DISPOSITION				AGAINST [DEPART	MENT	/PROCESS		
WOIR OIG	·'		T/			Rework	1 		Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	_	Quality
	_					Use-as-is	1 1		noforming	Finishing	\neg R		re/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
													·		
Root					Desci	ription of work order update		nitial	Acti		1 1	gn &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		ate	Verification	1	QC Inspector
Design	_														
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material	_		r											ļ	
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Offset/Setup															
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Unapproved			1	<u> </u>	<u> </u>		FΔI	UIT CA	TEGORY				<u> </u>		
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Zarran		ending				Bend]Folio/F	Program	Γ	Outs	ide Dim	nensions		Pressure/Forced
	-	•	ot Concei	ntric		BOM/Route		Grain		ļ l	_		tolerance		Set-up
	Н.	racks				Broken/Damage/Defect	\vdash	Hardwa	are	ļ		Incorre		-	Temperature/Cure
			nk/Ripple	/Wave		Burrs		4	ion Incomplete/Un	gualified	Part	Lost/M	issing		Weld
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:	\vdash	rushing				Countersink		4	gned/off center	Ī	Posi	tioned V	Wrong		
	├ ──	eat Trea	ıt			Cut Too Short		Mislab	_		Pow	er Loss/	/Surge		Other
	-		n Strip in	Tube		Drawing		Misrea	d						
	\blacksquare	larks/Ch	•			Drill Holes		Off-set							
	T	urning S	equence			Finish		Out of	Calibration						
	Πv	/ave/Tw	ist in Tul	эе		Fit/Function		Out of	Sequence	<u> </u>					

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Work Ord Tuesday, Augus				*12	N348*							Pag	;e 2
Item ID: Revision ID: Item Name:	D3602-1 Angle			Accept	*N900	040	100)*	Setup	Start Stop	1 71	S1*	
Start Date: Required Date Reference:	6/04/14 : 6/04/14	Start Qty: 6.00 Req'd Qty: 6.00	*6 *6		Cust Item :	ID:						,	
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	~1/		r
Sequence ID/ Work Center I 120 *1 20* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	•	Reject Number	Insp. Stamp DAS 38 9-89	
130				0.00				V ^-			t		

140

QC5- Inspect part completeness to step on W/O

Form as per Dwg D3602

0.00

0.00

140

Quality Control

120 Small Fab

Small Fab

Small Fab

Memo

Memo

0.00

DQA:			Date:										"DART
						WORK ORDER NON	-CC	NFO	RMANCE / UI			—	AEROSPACE
QA Closed:			Date:								Nork Order up	date only	
Work Orde	·r·	12 >	740			DISPOSITION	ļ			AGAINST [DEPARTMENT	/PROCESS	
Work Orge	-	120	0 10			Rework]		Skid-tube	Crosstube		Water Jet	/ Engineering
Part N	lo.	\mathcal{D}_3	602	-1		Scrap	1 1	ı	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-					Use-as-is]	Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	lo		*			Suspected Unapproved]		Large Fab	Composite		Supplier	
0	_		1		Dasa	rintian of work and a wadet		nitial	Act	ion	Sign &		T
Root Cause		Date	Step	Qty	Desc	ription of work order update or non-conformance	!	niciai ief Eng	1	ription	Date	Verification	QC Inspector
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Doc/Data	\dashv				Ya	it are scrap it cut with the pht meteriel + don't make is part anymore is st's malle by			6.	d. tre-	*		
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Handling/Pre		()			1.5	1+ motived +			۱ ۱ ۱	1-0-	58 14/08/15		
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Operator		191011			سرب	e don't proceed					1,1,04,2		
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Process	V				-he	e : of is made by							
Supplier				1	SF:	I							· ·
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							FA	ULT CA	regory				
Landir						General		1		Г			7p/r/
	-	Bending			<u> </u>	Bend	-		Program	•	Outside Dim		Pressure/Forced Set-up
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		Cracks	1 /0: 1		-	Broken/Damage/Defect	\vdash	Hardwa			Part Incorre	<u> </u>	Weld
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	-	Crushing	+		-	Countersink Cut Too Short	\vdash	Mislabe	gned/off center	}	Power Loss/		Other
	-	Heat Trea		Tubo	\vdash	Drawing	\vdash	Misrea		Ĺ		Juige	Tourier .
	-	Marks/Ch		iune		Drill Holes	-	Off-set					
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		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

Work Ord Tuesday, Augus				*120	1348*						Page
Item ID: Revision ID: Item Name:	D3602-1 Angle			Accept	*N900	040	100)*	Setup Sta		S1*
Start Date: Required Date Reference:	6/04/14 : 6/04/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:					
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run Sta	^I\ <u>I</u>	R1*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & St	ock Location:	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging		Memo		0.00							·

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

160

160

Quality Control

Scanled Scanled

DQA:			Date:		- <u></u>								"DART
						WORK ORDER NON	-CC	ONFO	RMANCE / U				AEROSPACE
QA Closed:			Date:							w	ork Order up	date only	
Work Orde	٠r.					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Work Orac	٠					Rework	1 1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming	Finishing		re/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite		Supplier	
Root			[Desc	ription of work order update	I	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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		Bending				Bend] Folio/f	Program	Γ	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	tolerance	Set-up
6		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	Temperature/Cure
*		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
	Г	Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	'Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration			<u> </u>	
		Wave/Tw	ist in Tub	ое		Fit/Function		Out of	Sequence				

Ricklist Print

Tuesday, August 12, 2014 11:59:28 AM

Work Order ID: 120348

120348

Parent Item:

D3602-1

D3602-1

Parent Item Name: Angle

Start Date: 6/04/14

Required Date: 6/04/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A

New Issue 07-02-27 JLM

IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA4P		Purchased	No		,	100	sf	36.0000	0.585	4			/ /
*M304S20 304/316 Sheet .040		17 gr. 1							**		De	14/	18/12
		•		Location		Loc (<u>Oty</u>	Loc Code				,	
				MAT020			36						
				<	m129146		36		_	4.1	_	•	

DQA:			Date:						_				"DART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPD		ork Order up	date only	AEROSPACE .
						DISPOSITION				AGAINST DE	·		
Work Ord	er: .						,				, 1	_	
0						Rework			—	Crosstube Small Fab	Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part I	NO					Scrap Use-as-is			Machining noforming	Finishing	4	e/Packaging	Other
NCR I	No.					Suspected Unapproved	}	men	· —	Composite	Nec/3tor	Supplier	
	•						'			,			
Root					Desc	ription of work order update		nitial	Action	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	QC Inspector
Design					i								
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator	Ш												
Offset/Setup			1										
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Supplier													
Training							1						
Transport					,								
Unapproved							<u> </u>						
							FA	ULT CA	TEGORY				
Landi	<u> </u>	1				General	_	1			.	. –	¬₋ .
		Bending				Bend		4 `	Program	ļ	Outside Dim	<u> </u>	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	 	Set-up
		Cracks				Broken/Damage/Defect		Hardwa		<u> </u>	Part Incorred	-	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave	<u> </u>	Burrs		4	tion Incomplete/Unqu		Part Lost/Mi	ssing	Weld
		Cuffs			<u> </u>	Contamination	\vdash	4	tions Incomplete/Und	clear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink	\vdash		gned/off center		Positioned V	_	¬ .
		Heat Trea			<u> </u>	Cut Too Short	\perp	Mislab			Power Loss/	Surge	Other
		Inspectio	-	Tube		Drawing	_	Misrea					
		Marks/Cl				Drill Holes		Off-set					
		ŧ	Sequence			Finish	_	4	Calibration			-	
	L	Wave/Tw	vist in Tuk	oe		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	120348
Description: Angle	Part Number:	D3602-1
Inspection Dwg: D3602 Rev: B		Page 1 of 1

	Γ	ARTICLE IN		_			
	X	First Artic	le	_ Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
36.25	+/-0.030	36.25			T	JKM	- 06
2.348	+/-0.010	2.352	V		V	JKM	1-01
R0.13	+/-0.030	0.13	7		V	JKM JKM JKM	1-01
		,					:
	1		DAS	-			
asured by:	De/A	Audited by:	38 9-89		Prototype A	pproval:	N/A
	4/08/12	Date:	14/08	1/13		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.05.27	New Issue	KJ 📆	

36.25 REF R347 REF 🖄 B 3.05 AC1-1 **D3602-1 ANGLE** SECTION A-A SCALE 2X (MAKE FROM D3602-1F) SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE B 2.348 WORK ORDER MUS **D3602-1F FLAT PATTERN** R0.13 TYP 1406-00 ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014 MB 09.02.02 A NEW ISSUE MB 07.02.20 REV. DATE DESCRIPTION BY DESIGN DART AEROSPACE LTD 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B 2) FINISH: NOME
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER D3602 MFG. APPR. SHEET 1 OF 1 APPROVED TITLE SCALE DE APPR. **ANGLE** NTS COPYRIGHT © 2007 BY DART AEROSPACE LTD 7) WEIGHT: 0.97 lbs DATE 09.02.02 8 6